

# Work Order ID 75177

**\*75177\***

Page 1

October-18-11 2:00:44 PM

Item ID: D412-630-031 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Pilot/Co-Pilot Step, LH (Folding)  
 Start Date: 18/10/2011 Start Qty: ~~2.00~~ **\*2\*** Cust Item ID:  
 Required Date: 04/11/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 11/10/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
IIN D412-630	Rev M								
100		0.00							
<b>*100*</b>	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003								
110		0.00							
<b>*110*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D412-630 p.17								
	****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****								
120		0.00							
<b>*120*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control	****ensure tension to retract step is 11 to 18 lbs ****								

*Handwritten:* 11/10/31 (1) MLJ 11-10-31

*Handwritten:* SB 11/10/31 (1)

*Handwritten:* SB 11/10/31 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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 Start Date: 18/10/2011 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 04/11/2011 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							Sp 11-10-31
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
<b>*140*</b>									
QC	Memo	0.00							M 11/11/01 ①
Quality Control									
150		0.00							
<b>*150*</b>									
Packaging	Packaging								Sp 11-11-1
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-031								
	Location: _____								
	PPP Rev: <u>D</u>								

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 75177****\*75177\***

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Item ID: D412-630-031

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 04/11/2011 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

11/11/02

mf  
11-11-01

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 75177

**\*75177\***

Parent Item: D412-630-031

**\*D412-630-031\***

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC  
IPP REV. B 05.12.19 updated pick list EC  
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>*AN310-4*</b> NUT		Purchased	No			130	Each	29.0000	1	21			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		29							
					118983	25							
					119084	4							
<b>*AN310-5*</b> NUT		Purchased	No			130	Each	30.0000	2	2			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		30							
					118112	30							
<b>*AN3C5A*</b> Bolt		Purchased	No			130	Each	1,316.000	3	3			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP-A		7							
					115835	7							
				ST350		1309							
					116419	28							
					117343	110							
					117764	169							
					117872	2							
					118451	500							
					119127	500							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

AN44-C12

Purchased

No

130

Each

10.0000

1

21

**\*AN44-C.12\***

eyebolt

\*\*

SP

Location

Loc Qty

Loc Code

ST362

10

117616

10

Purchased

No

130

Each

16.0000

1

21

AN4C15

**\*AN4C15\***

BOLT

\*\*

SP

Location

Loc Qty

Loc Code

ST358

16

118091

1

118652

15

Purchased

No

130

Each

20.0000

1

21

AN5C11

**\*AN5C11\***

BOLT

\*\*

SP

Location

Loc Qty

Loc Code

ST337

20

114801

20

Purchased

No

130

Each

14.0000

1

21

AN5C15

**\*AN5C15\***

BOLT

\*\*

SP 11-10-31

Location

Loc Qty

Loc Code

ST338

14

117616

14

1K

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D412-630-031

**\*D412-630-031\***

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C516

Purchased No

130

Each

18.0000

1 21

\*\*

**\*AN960C516\***

WASHER

Location

Loc Qty

Loc Code

ST347

18

102842

18

Manufactured No

130

Each

7.0000

1 21

\*\*

D3454-1

**\*D3454-1\***

Bushing

Location

Loc Qty

Loc Code

ST054

7

58555

7

Manufactured No

130

Each

24.0000

2 42

\*\*

D3454-3

**\*D3454-3\***

Bushing

Location

Loc Qty

Loc Code

ST054

24

68467

4

73348

20

Manufactured No

130

Each

26.0000

2 42

\*\*

D3454-5

**\*D3454-5\***

Bushing

Location

Loc Qty

Loc Code

ST054

26

70527

6

73343

20

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75177

\*75177\*

Parent Item: D412-630-031

\*D412-630-031\*

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

D3455-1

Manufactured No

130

Each

41.0000

4

\*\*

\*D3455-1\*

Spacer

## Location

## Loc Qty

## Loc Code

ST054

41

72133

1

73302

40

Manufactured No

130

Each

18.0000

2

\*\*

D3455-3

\*D3455-3\*

Spacer

## Location

## Loc Qty

## Loc Code

ST054

18

68470

1

72163

17

Manufactured No

130

Each

2.0000

1

\*\*

D3462-041

\*D3462-041\*

Bracket Assembly

## Location

## Loc Qty

## Loc Code

ST198A

2

72030

2

Purchased No

130

Each

921.0000

3

\*\*

MS21043-3

\*MS21043-3\*

Nut

## Location

## Loc Qty

## Loc Code

FG

72

103691

72

ST301

849

118077

1

118614

492

118686

356

October-18-11 2:00:49 PM

Shop Packet Print

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75177

**\*75177\***

Parent Item: D412-630-031

**\*D412-630-031\***

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-227

Purchased

No

130

Each

84.0000

2

42

**\*MS24665-227\***

COTTER PIN

\*\*

SP

Location

Loc Qty

Loc Code

GA

84

111041

84

Purchased

No

130

Each

297.0000

2

42

MS24665-229

**\*MS24665-229\***

COTTER PIN

\*\*

SP

Location

Loc Qty

Loc Code

GA

195

118234

195

ST309

102

111041

102

Purchased

No

130

Each

3,939.000

7

47

NAS1149C0363R

**\*NAS1149C0363R\***

Washer

\*\*

SP

Location

Loc Qty

Loc Code

ST297

3939

114742

3939

Purchased

No

130

Each

163.0000

1

7x

NAS1515H5

**\*NAS1515H5\***

Washer

\*\*

SP 11-10-31

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

123

103286

100

118384

23

1x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75177

**\*75177\***

Parent Item: D412-630-031

**\*D412-630-031\***

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

D3463-041

Manufactured No

110

Each

2.0000

1

2

\*\*

**\*D3463-041\***

Step Weldment Assembly

Location

Loc Qty

Loc Code

ST494

2

72201

2

Manufactured No

110

Each

2.0000

1

2

\*\*

D3443-043

**\*D3443-043\***

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

2

70525

2

Manufactured No

110

Each

1.0000

1

2

\*\*

D3443-041

**\*D3443-041\***

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST198A

1

71138

1

Manufactured No

110

Each

12.0000

2

4

\*\*

D3443-9

**\*D3443-9\***

Pin

Location

Loc Qty

Loc Code

ST054

12

72029

4

74699

8

October-18-11 2:00:49 PM

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D412-630-031

**\*D412-630-031\***

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

D3454-7

**\*D3454-7\***

Bushing

Manufactured No

110

Each

26.0000

2

4

\*\*

Location

Loc Qty

Loc Code

ST054

20

73346

20

ST058

6

70528

6

Manufactured No

110

Each

41.0000

2

4

\*\*

Location

Loc Qty

Loc Code

ST054

41

72133

1

73302

40

Manufactured No

110

Each

25.0000

1

2

\*\*

Location

Loc Qty

Loc Code

ST054

25

46134

5

73449

20

Manufactured No

110

Each

36.0000

2

4

\*\*

Location

Loc Qty

Loc Code

ST357

36

117616

1

118131

5

118757

10

118758

20

D3465-1

**\*D3465-1\***

Washer

Manufactured No

110

Each

25.0000

1

2

\*\*

Location

Loc Qty

Loc Code

ST054

25

46134

5

73449

20

Manufactured No

110

Each

36.0000

2

4

\*\*

Location

Loc Qty

Loc Code

ST357

36

117616

1

118131

5

118757

10

118758

20

AN4CH3

**\*AN4CH3\***

SS Bolt

Purchased No

110

Each

36.0000

2

4

\*\*

Location

Loc Qty

Loc Code

ST357

36

117616

1

118131

5

118757

10

118758

20

October-18-11 2:00:50 PM

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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

AN4C14

Purchased

No

110

Each

26.0000

1

2

\*\*

**\*AN4C14\***

BOLT

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

1

114669

1

AN310-4

Purchased

No

110

Each

29.0000

1

2

\*\*

**\*AN310-4\***

NUT

Location

Loc Qty

Loc Code

ST324

29

118983

25

119084

4

AN310-7

Purchased

No

110

Each

28.0000

1

2

\*\*

**\*AN310-7\***

NUT

Location

Loc Qty

Loc Code

ST324

28

114784

28

MS24665-227

Purchased

No

110

Each

84.0000

1

2

\*\*

**\*MS24665-227\***

COTTER PIN

Location

Loc Qty

Loc Code

GA

84

111041

84

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 18/10/2011

Required Date: 04/11/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-302

Purchased

No

110

Each

115.0000

1

2

**\*MS24665-302\***

Cotter Pin

\*\*

*[Signature]*  
11/10/31

Location

Loc Qty

Loc Code

ST357

115

117460

115

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

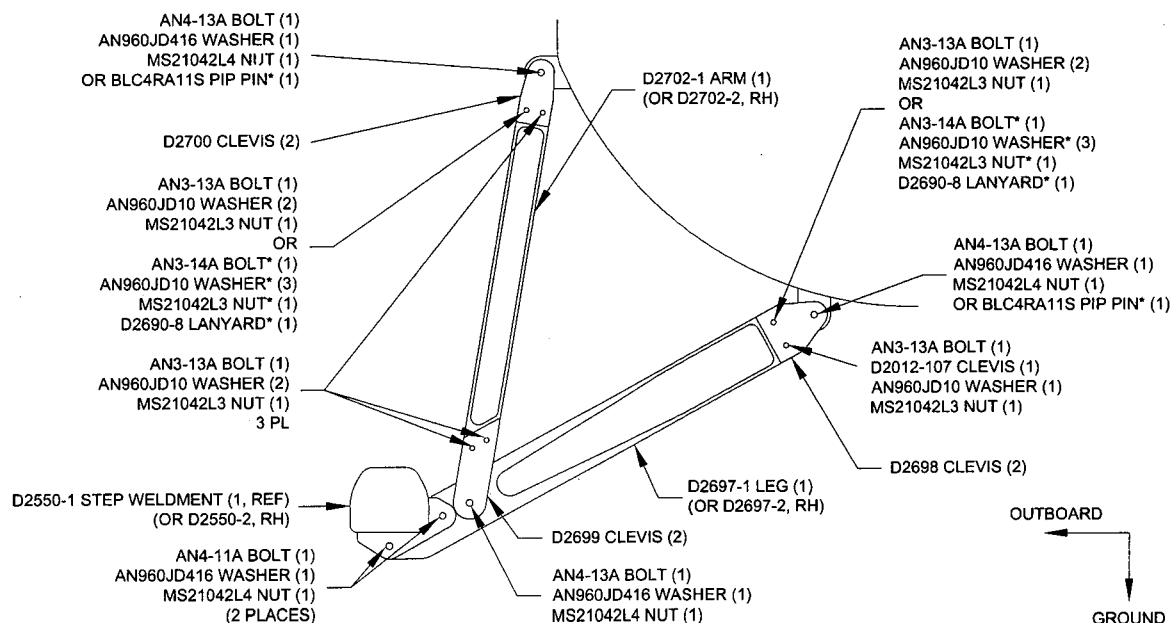
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

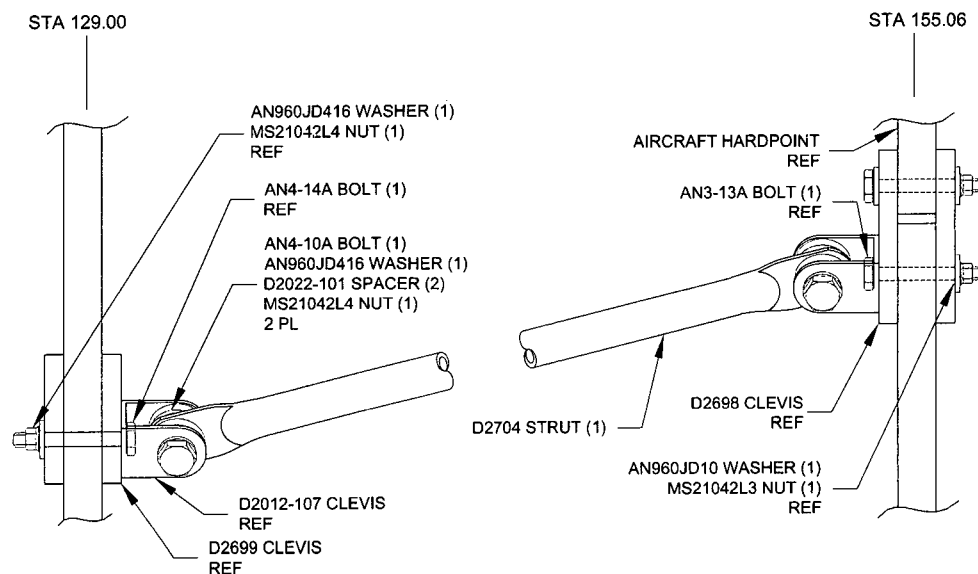
**NOTE:** Date & initial all entries





**FIGURE 19 – STA 155.06 for D412-630-111/112 Heli-Access-Step™ Installation**

**Note: \* use these parts with optional pip pin only  
(View rotated 90° CW)**



**FIGURE 20 – Strut Detail for D412-630-111/-112 Heli-Access-Step™ Installation  
(NOT TO SCALE)**

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Revision: **M**  
Date: 08.12.12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING }
2	2	D3454-3	BUSHING }
2	2	D3454-5	BUSHING }
2	2	D3454-7	BUSHING }
6	6	D3455-1	SPACER }
2	2	D3455-3	SPACER }
1		D3462-041	BRACKET ASSEMBLY }
	1	D3462-042	BRACKET ASSEMBLY }
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT }
2	2	AN310-5	NUT }
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT }
1	1	AN44-C12	* EYEBOLT }
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT }
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT }
1	1	AN5C15	BOLT }
7	7	AN960C10	WASHER }
1	1	AN960C516	*WASHER }
3	3	MS21043-3	NUT }
2	2	MS24665-227	COTTER PIN }
2	2	MS24665-229	COTTER PIN }
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER }

\* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP